

6061TC ①.563

Work Order ID 150149

Wednesday, August 24, 2016 11:42:02 AM

150149

Page 1

Item ID: 646.9910

Revision ID:

Item Name: Struts

Start Date: 8/10/2016 Start Qty: 20.00

Required Date: 8/24/2016 Req'd Qty: 20.00

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan:

DAS

21

Date: AUG 24 2016

Tooling:

Date:

Run Start

NR1

QC:

9-89

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

646.9900

N/C

110

0.00

110

Doosan

Memo

0.00

Doosan Lathe

*** CUT BLANK ON CHOP SAW AT 24.125" LONG***

TURN AS PER DWG

DWG REV: N/CFOLIO REV: AA

DEBURR

30

φ

V

DAS

45

9-89

2016-9-22

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

30

φ

H

2016-9-22

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube ☐</td> <td style="width:12.5%;">Cross tube ☐</td> <td style="width:12.5%;">Water Jet ☐</td> <td style="width:12.5%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																					
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Work Order ID 150149***150149***

Page 2

Wednesday, August 24, 2016 11:42:02 AM

Item ID: 646.9910 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Struts
Start Date: 8/10/2016 Start Qty: 20.00 ***20*** Cust Item ID:
Required Date: 8/24/2016 Req'd Qty: 20.00 ***20*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC8- Inspect parts - second check	0.00							
170									
QC	Memo	0.00							DAS 08 9-89
Quality Control									
180	PURCHASING	0.00							DAS 13 9-89
180									
Outsource4	Memo	0.00							
Outsource process - Anodize	Issue P/O to ATG : <u>33802</u>								
	1- Black Anodize as per Dwg 646.9900								
	2- PRIME AS PER DWG, SEE NOTE #2								
	Certification of Comformity is required								
190	Receive & Inspect for Damage & Mat'l Certs	0.00							
190									
Packaging	Memo	0.00							
Packaging	Ensure certificate of conformity is attached								

Box 276-10-17

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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		OTHER : _____																			

Picklist Print

Wednesday, August 24, 2016 11:42:05 AM

Page 1
1

Work Order ID: 150149

150149

Parent Item: 646.9910

646.9910

Parent Item Name: Struts

Start Date: 8/10/2016

Required Date: 8/24/2016

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A NEW ISSUE 12-09-19 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.563		Purchased	No				f	45.7640		44.21053			
M6061T6R0 563									**			16-9-21	
6061-T6 ROUND BAR .563													

Location

Loc Qty

Loc Code

MAT012

45.764

m126852

33.764 24

m135377

12

135559

20.2
12/10/09

30.25

DQA: _____ Date: _____



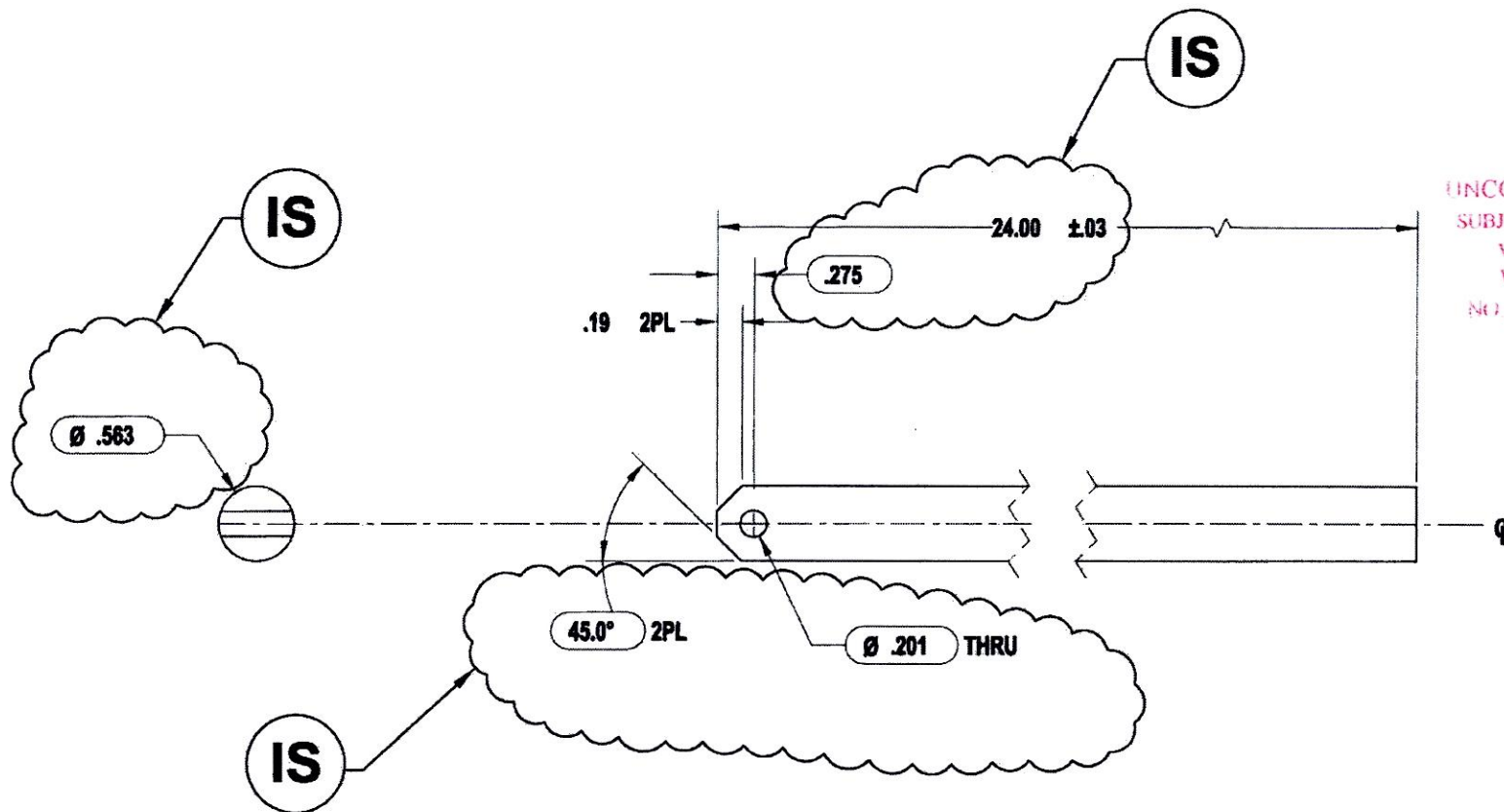
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 03728				SHEET 1 OF 1	
	DWG NO. 646.9900	REV: N/C	PREPARED BY B. PETERS	DATE: 12/05/12	EFFECT ON DWG ☐ INC. ☒ UNINC.	
	DWG TITLE: STRUT					
	APPROVED BY: ENGR <i>[Signature]</i>	MFG <i>[Signature]</i>	QC <i>[Signature]</i>	EFF: NEXT ORDER		
TRANSACTION CODES (TC) A-ADD C-CREATE R-REVISE D-DELETE	REASON: REVISED LENGTH TOLERANCE AND CRITICAL DIMENSIONS.				ECR: D-12-014	



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 150149 MO
160824

SHEET 1 IS:

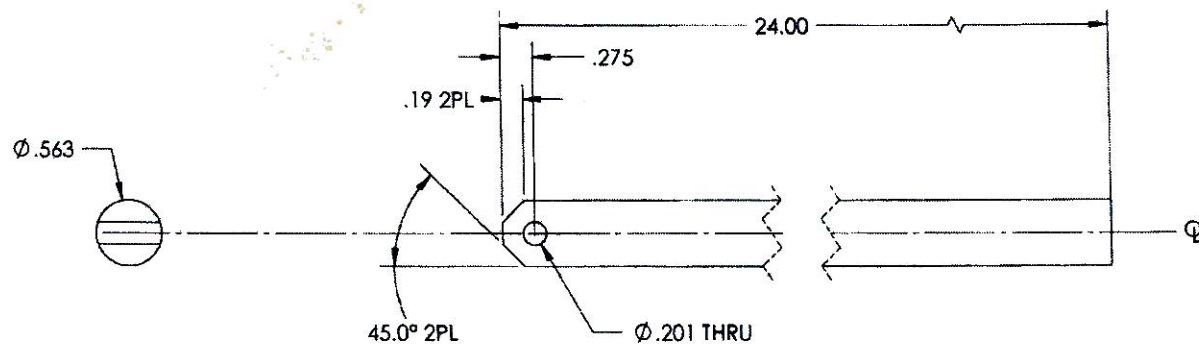
DOCUMENTS EFFECTED:	☐ RFMS ☐ MDL ☐ INSTALL INSTRUC ☐ ICA ☐ BOM	CHANGE CATEGORY ☐ MAJOR ☒ MINOR	DER REVIEW REQUIRED ☐ YES ☒ NO
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REV	DESCRIPTION	DATE	APPROVED
1	LAST PROTOTYPE DESIGN PER		LUC
2	REPAIR RELEASE	04/27/80	P. BRAYO

NOTES:

- 1 MATERIAL: 6061-T6 ALUMINUM BAR IAW AMS-QQ-A-250/11
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK
CARDINAL 4860-50 PRETREATMENT PRIMER
PRIME IAW MIL-P-23377J TYPE I CLASS N
- 3 DEBURR AND BREAK ALL SHARP EDGES
- 4 IDENTIFY IAW MPP-120



646.9910

QTY	PART #	DESCRIPTION	MATL	SPEC.
	646.9910	STRUT		
PARTS LIST				
NEXT ASSY (S)		APICAL INDUSTRIES		
646.9500		2608 TEMPLE HEIGHTS DR.		
		OCEANSIDE, CA. 92056-3512 (760)724-5300		
		STRUT		
		SCALE NONE		
		SHEET 1 OF 1		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO33802**

Purchase Order Date 9/29/2016

PO Print Date 10/12/2016

Page Number 1 of 3

Order From :

VC-ATG001

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED

OCT 12 2016

Contact Name

Vendor Phone

613-446-4544

Ship To Contact

Ship To Phone

Ship Via:

VENDOR'S TRUCK

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
Line Comments			Promise Date				
Delivery Comments							

1	150149	646.9910 STRUT REV. N/C	10/17/2016		30.00	\$11.90	\$357.00
			No				
			10/17/2016				

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE I CLASS N

Line Total: \$357.00

2	150884	647.4212 PLATE REV. N/C	10/17/2016		10.00	\$6.55	\$65.50
			No				
			10/17/2016				

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE I CLASS N

Line Total: \$65.50

Note:

10/12/2016



A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
ROCKLAND, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 912400

Date: 17-Oct-16

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

CHANTAL LAVOIE
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
Quantity	Description		
PLEASE REFERENCE THE PACK LIST NUMBER ON ALL CORRESPONDENCE TO THIS SHIPMENT. IF YOU HAVE ANY QUESTIONS, PLEASE CALL AT (613) 446-4544.			
1 ea	Part: ADMINISTRATION FEE ADMINISTRATION FEE Job: 20266	Rev: N/A PO: Line:	
30 ea	Part: 646.9910 Strut Hard Anodize, Type III, Class 2 (MIL-A-8625) Primer, MIL-P-23377J, TYPE 1, CLASS N Job: 20263	Rev: AS 38 -89 PO: 33802	Line: 1
10 ea	Part: 647.4212 Plate Hard Anodize, Type III, Class 2 (MIL-A-8625) Primer, MIL-P-23377J, TYPE 1, CLASS N Job: 20264	Rev: N/C PO: 33802	Line: 2
5 ea	Part: 646.3813 Strut Hard Anodize, Type III, Class 2 (MIL-A-8625) Primer, MIL-P-23377J, TYPE 1, CLASS N Job: 20265	Rev: N/C PO: 33802	Line: 3
DATE: 17/10/16 CERTIFIED SIGNATURE: RECEIVER SIGNATURE: _____			
Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
CERTIFICATE OF CONFORMANCE			



A.T.G. INDUSTRIES INC.
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Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
Quantity	Description		
	A.T.G. INDUSTRIES INC. CERTIFIES THAT ALL ITEMS IN THIS SHIPMENT CONFORM TO REQUIREMENTS.		
	MADE IN CANADA.		
	DAS 38 9-89		
	Sp/6-10-17.		